

Work Order ID 96081

February-11-13 10:41:38 AM

HAI

96081

Duplicate

Page 1

Item ID: D4552-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Sliding Window Assembly, LH

Start Date: 1/21/13 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 2/22/13 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 13-02-11 Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4552	A								
120	Pick Kit	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130		0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- Install D4550-099 window pile and D4567-1 knob as per dwg Sikaflex Black B#								
	2- engrave part# and batch# as per dwg								
	3- wrap window using saran wrap								

D45
13/02/11

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Page 2

Item ID: D4552-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Sliding Window Assembly, LH

Stop ***NS2***

Start Date: 1/21/13 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/22/13 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

04700 Feb

MF
13-2-27

February-11-13 10:41:41 AM

96081

D4552-041

Required Date: 2/22/13

Required Qty: 1.00

IPP Rev B

[illegible]

Picklist Print

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Work Order ID: 96081

Parent Item: D4552-041

Parent Item Name: Sliding Window Assembly. LH

96081

D4552-041

Start Date: 1/21/13

Required Date: 2/22/13

Start Qty: 1.00

Required Qty: 1.00

MS20392-2R41P

Purchased

No

120

Each

1.0000

1

~~*MS20392-2R41P*~~

Drilled Pin

**

Location

Loc Qty

Loc Code

GA

1

~~120675~~

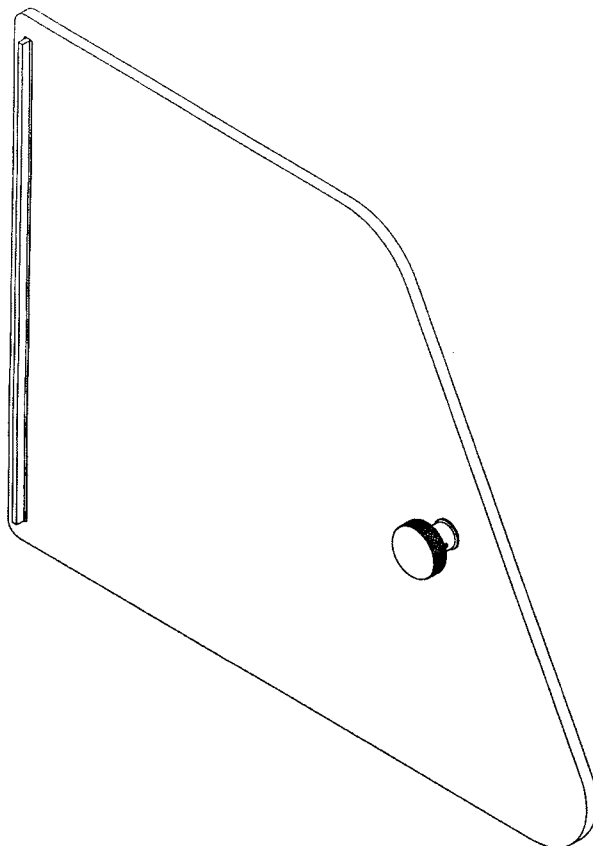
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123916

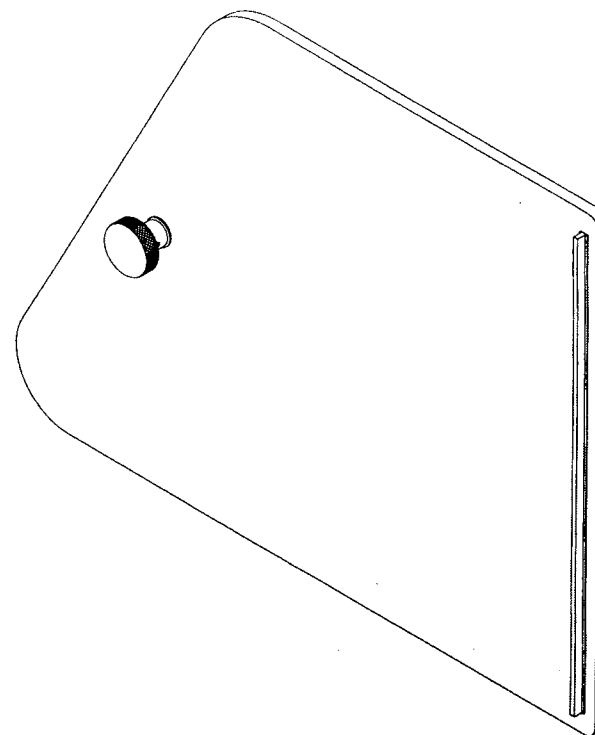
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HL32PB8-14

13/02/21



D4552-041 SLIDING WINDOW ASSY (LH)



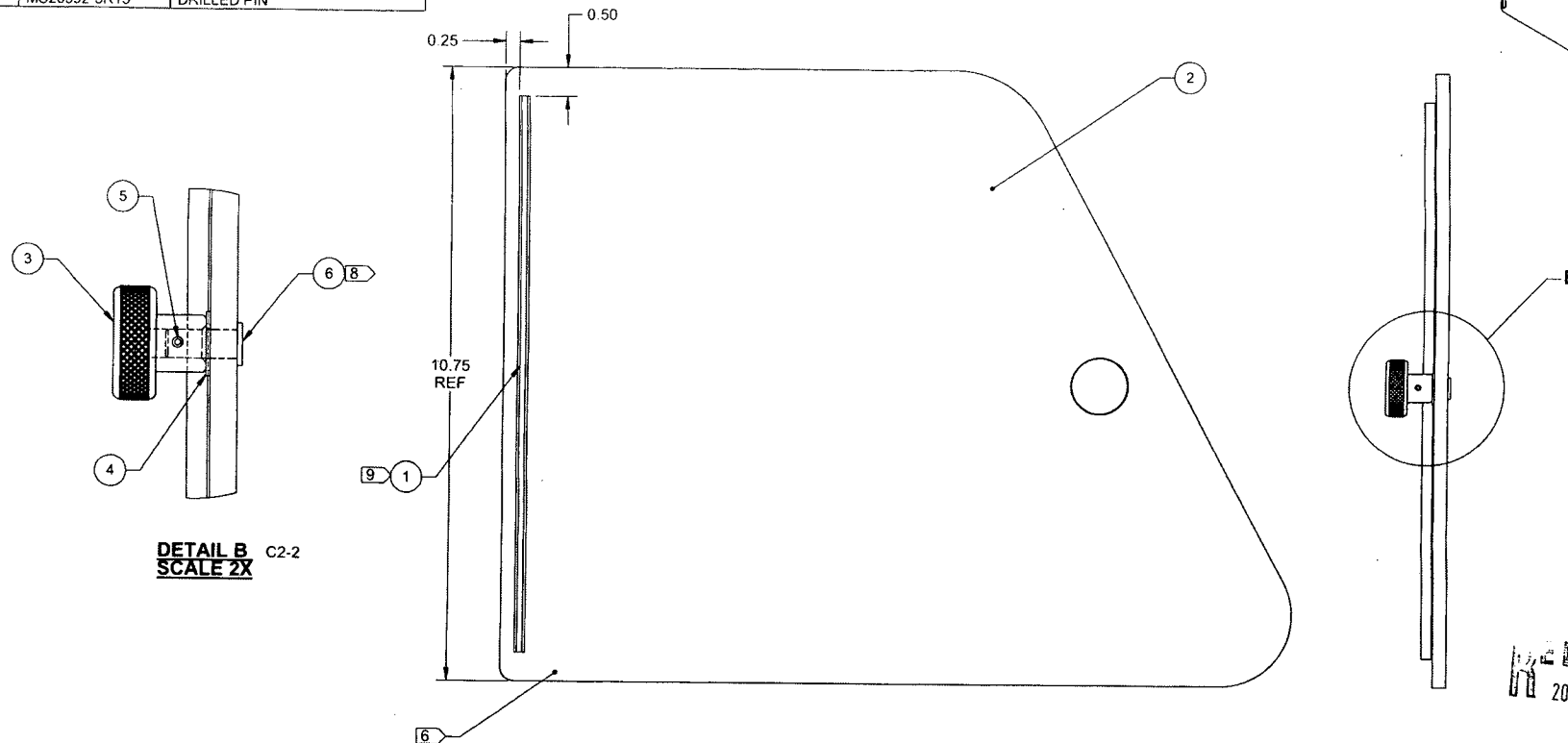
D4552-042 SLIDING WINDOW ASSY (RH)

RELEASED
2012-03-08
WJP

96081 MLC
13-02-11

A	NEW ISSUE		AP	12.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD		
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	<i>[Signature]</i>	D4552	SHEET 1 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	SLIDING WINDOW ASSY	NTS	
DATE	12.02.27	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		





ITEM	QTY	P/N	DESCRIPTION
	X	D4552-041	SLIDING WINDOW ASSY, LH
1	1	D4550-097	WINDOW PILE
2	1	D4566-1	SLIDING WINDOW
3	1	D4567-1	KNOB
4	1	D4602-1	SPRING WASHER
5	1	MS16562-213	SPRING PIN
6	1	MS20392-3R15	DRILLED PIN



D4552-041 SLIDING WINDOW ASSY (LH)

NOTES:

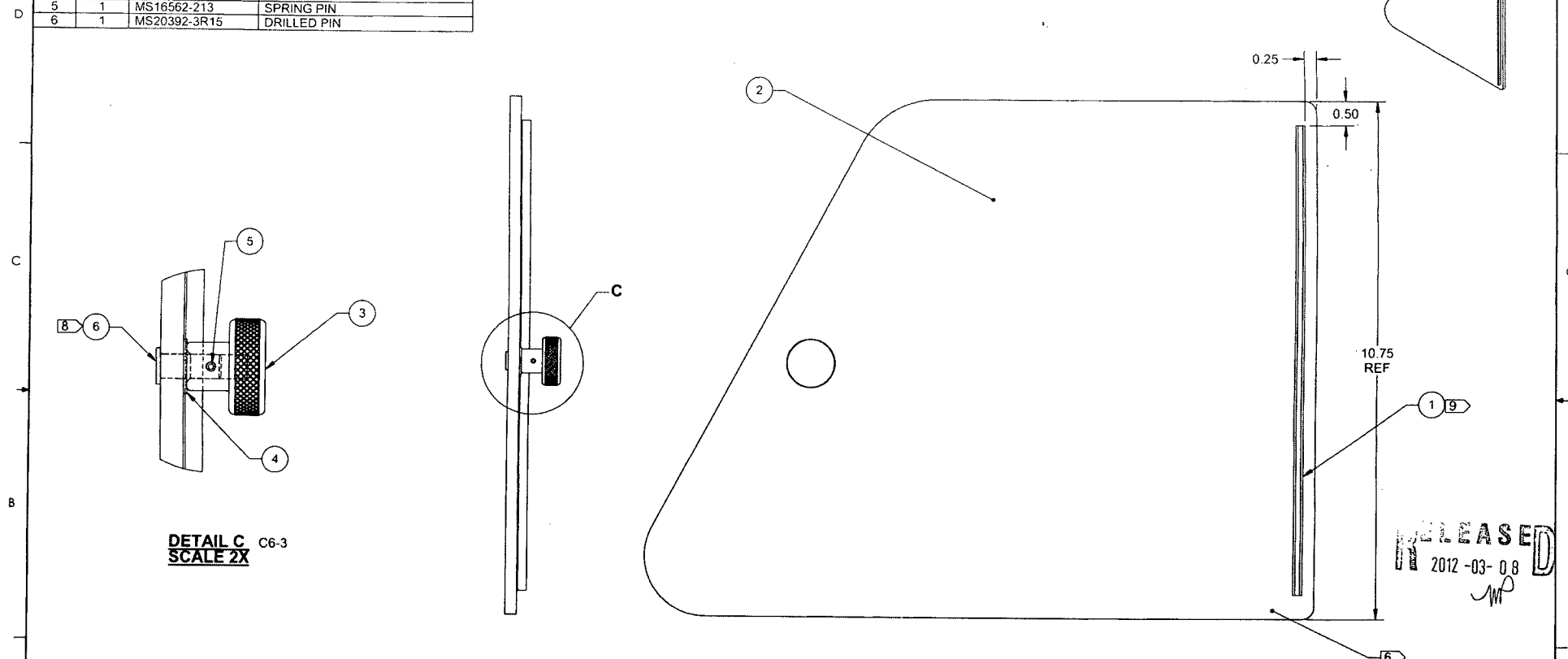
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D4552-041" & B/N "BXXXXX" WITHIN 0.125" FROM THE EDGE OF WINDOW. USE 0.125" LETTERS TO MAX DEPTH OF 0.005 PER DART QSI 044 6.4 USING VIBRATING STYLUS.
- 7) WEIGHT: 1.32 lbs
- 8) ENLARGE HOLE IN ITEM 6, PIN, TO $\phi 0.046$ "
- 9) INSTALL WITH 3M SCOTCH-WELD 1300L RUBBER & GASKET ADHESIVE

DESIGN	AP	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4552	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDING WINDOW ASSY	NTS
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2012-03-08

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5	1	MS16562-213	SPRING PIN
6	1	MS20392-3R15	DRILLED PIN



DETAIL C C6-3
SCALE 2X

D4552-042 SLIDING WINDOW ASSY (RH)

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CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AP	D4552	SHEET 3 OF 3
APPROVED	AP	TITLE	SCALE
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